



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4273-042
Job Sheet 184063



5

Part No: D4273-042

Job Qty: 1 ea

Part Name: Basket Base Assembly, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/2/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4279 REV B SHEETS 1,2, D4273 REV F SHEETS 6,7,8,9,10 IPP Rev:A 10.11.16 new issue DD
verf:EC IPP Rev:B 11.01.20 AS PER DWG REV.C DD verf:EC IPP Rev:C 11.03.03 AS PER DWG REV.D DD
verf:EC IPP REV:D 12.07.24 AS PER DWG REV.E DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/9/18	0.00	0.00	Start Up Large Fab-6		SD
100	Large Fab	1 pcs		11/9/18	0.00	31.15	Large Fab 1		SD
110	QC	1 pcs		11/9/18	0.00	0.00	QC9		CPL
120	QC	1 pcs		11/9/18	0.00	0.00	QC5		CPL
125	HandFinish	1 pcs		11/9/18	0.00	0.40	HandFinish2		BFB 18-10-23
130	Powdercoat	1 pcs		11/9/18	0.00	0.67	Powdercoat2		DL 18-10-23
140	QC	1 pcs		11/9/18	0.00	0.00	QC3		W 18-10-25
150	Packaging	1 pcs		11/9/18	0.00	0.00	Packaging3-2		21 18-10-25
160	QC21-SA	1 Ea		11/9/18	0.00	0.00	QC21		9-88 OCT 25 2018

Part Op 100 - 1- assemble ribs and handle plates (DO NOT WELD HANDLE IN SECTION N-N ON PAGE 7 DWG D4273, NEED
Descriptions: TO WELDED AFTHET MESH IS INSTALL) weld as per dwg D4273 using DT10317 2- Cut D4279-1 (MADE ON THIS
W/O) base mesh and tack weld all mesh on basket as per dwg D4273 and trim mesh to fit if necessary and trim to clear
fasteners holes on the ends (D4279-5/-9)

130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat

M 138951 START: 2005 O.V.T: 375° FINISH: 200

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5097502
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	5112746
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5108592
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	5112730
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5104485
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	511458
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	5115309
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	5110037
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	5108590
D4277-19	Rib	1 Ea (1 ea)	90-Start up Operation	5115591
D4277-3	Rib	1 Ea (1 ea)	90-Start up Operation	5110971
D4277-5	Rib	2 Ea (2 ea)	90-Start up Operation	5001976
D4277-9	Rib	1 Ea (1 ea)	90-Start up Operation	5110979
D4278-041	Upper Rib Assembly-Hoop	1 Ea (1 ea)	90-Start up Operation	5017978
D4278-045	Rib Assembly, Fwd Cham	2 Ea (2 ea)	90-Start up Operation	5115916

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

D4278-047	Upper Rib Assembly-Straight	1 Ea (1 ea)	90-Start up Operation	<u>5078860</u>
* D4279-5	End Mesh, Basket	1 Ea (1 ea)	90-Start up Operation	<u>5117699</u>
D4279-7	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	<u>5083614</u>
D4279-9	End Mesh, Basket	1 Ea (1 ea)	90-Start up Operation	<u>5083812</u>
D4306-044	Rib Assembly, RH	1 Ea (1 ea)	90-Start up Operation	<u>5062859</u>
D4306-045	Rib Assembly	1 Ea (1 ea)	90-Start up Operation	<u>5061084</u>
D4306-1	Rib	1 Ea (1 ea)	90-Start up Operation	<u>5061190</u>
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation	<u>5098052</u>
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	90-Start up Operation	<u>5093684</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	76	0
	D3913-1	1	10	0
	D3913-15	1	12	0
	D3913-3	1	11	0
	D3913-9	1	5	0
	D3916-5	3	17	0
	D4016-1	3	37	0
	D4017-7	3	31	0
	D4021-1	3	27	0
	D4277-19	1	0	0
	D4277-3	1	6	0
	D4277-5	2	2	0
	D4277-9	1	6	0
	D4278-041	1	1	0
	D4278-045	2	0	0
	D4278-047	1	2	0
	D4279-5	1	2	0
	D4279-7	2	7	0
	D4279-9	1	8	0
	D4306-044	1	3	0
	D4306-045	1	2	0
	D4306-1	1	4	0
	D4672-1	2	22	0
	M304EX0.75-16F	32	1,601	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER N

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rework Scrap Use-as-is Suspected Unapproved
Part No. _____	
NCR No. _____	

Date : _____	Step #: _____
--------------	---------------

Description Work Order Deviation

--

QC / QA Coordinator
Approval

Root Cause				FAULT CATEGORY						
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

DART
AEROSPACE
Container No: S118025
Part: D4273 - 042
Job No: 184063
Serial No/Batch: S118025
Revision:
Inspector:
Exp Date:
Instructions: Various STC's
Date: 10/6/18

Dart Aerospace Ltd.
1270 Aberdeen Street
Newbury, ON K6A 1K7
CANADA
TEL: 1 613 632-6200
Email: sales@dartaero.com
www.dartaerospace.com